

***Abstract Of the Disclosure***

A method of using a tool for punching orifice that has wall surfaces extending at an angle relative to a generally planar surface of a workpiece. The method includes sequentially forming two spaced apart impressions formed in the workpiece between first and second generally planar surfaces spaced apart along a longitudinal axis of the workpiece. The two spaced apart impressions form a first orifice wall surface disposed at an obtuse angle with respect to the generally planar surface facing the tool and a second orifice wall surface disposed at an acute angle with respect to the generally planar surface, and coincidental with the punching process, a retention arrangement that secures the workpiece during the forming of the orifice.